

Thursday, December 03, 2015 1:09:00 PM

139211

Page 1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Bracket (Supersedes B67-43001-273)

Stop *NS2*

Start Date: 11/16/2015 **Start Qty:** 8.00 ***g***

Cust Item ID:

Required Date: 12/11/2015 **Req'd Qty:** 8.00 ***O***

Customer:

Reference:

Approvals: Process Plan: MLS Date: DEC 03 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																					
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OTHER :																																																													

Work Order ID 139211

Thursday, December 03, 2015 1:09:01 PM

139211

Page 2

Item ID: D3440-13 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket (Supersedes B67-43001-273)
 Start Date: 11/16/2015 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 12/11/2015 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00				8	0		DAS 14 9-89 16/01/11
Quality Control									
140	Identify as per dwg & Stock Location: <i>Mat 2</i>	0.00							
140									
Packaging	Memo	0.00				8X			DAS 26 9-89 JAN 11 2016
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

MC5 JAN 12 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER :							

Picklist Print

Thursday, December 03, 2015 1:09:03 PM

Page 1

Work Order ID: 139211

139211

Parent Item: D3440-13

D3440-13

Parent Item Name: Bracket (Supersedes B67-43001-273)

Start Date: 11/16/2015

Required Date: 12/11/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A05.07.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.00 0		Purchased	No			100	f	7.4200	0.1833	1.543579			

M6061T6B2 000X02 000

6061-T6 Bar 2.00 x 2.00

21 16-1-4

Location

Loc Qty

Loc Code

MAT004

7.42

m129375

7.42

1.5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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DART AEROSPACE LTD		Work Order:	139211
Description: Bracket		Part Number:	D3440-13
Inspection Dwg: D3440	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

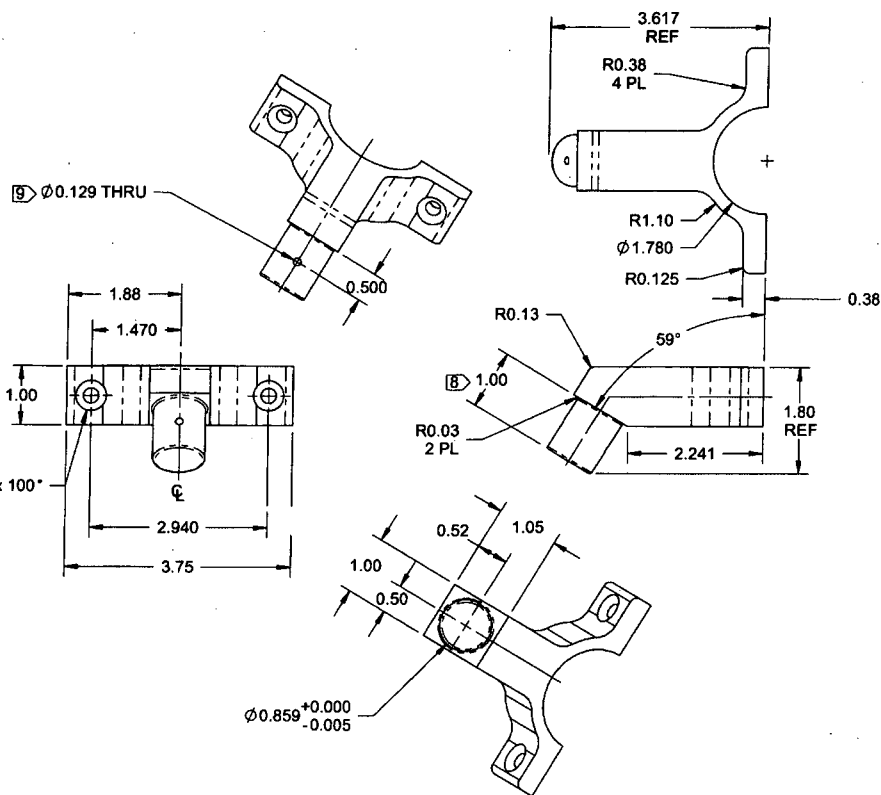
☒
First Article
☒
Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
30°	+/-0.5°	30°	✓		protractor	
0.40	+/-0.030	.400	✓		VERW	SL-10
0.500	+/-0.010	.504	✓		HG	
0.450	+/-0.010	.450	✓		VERW	
2.00	+/-0.030	1.991	✓		-	
78 0.776	+/-0.010	.786	✓		HG	
1.06	+/-0.030	1.063	✓		VERW	
R0.875	+/-0.010	.875	✓		-	
2.28 2.280	+/-0.010	2.286	✓		HG	
1.400 1.405	+/-0.010	1.408	✓		VERW	
1.200	+/-0.010	1.204	✓			
1.88	+/-0.030	1.878	✓			
0.563	+/-0.010	.563	✓			
0.250	+/-0.010	.251				
0.250	+/-0.010	.249				
Ø0.257	+0.006/-0.001	.257	✓		g-PIN	
Ø0.375	+0.006/-0.001	.3755	✓		g..	
1.32 0.085	+/-0.010	.134	✓		VERW	

DAS

Measured by:	SL	Audited by:	T4 9-89	Prototype Approval:	N/A
Date:	16-1-7	Date:	16/01/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	

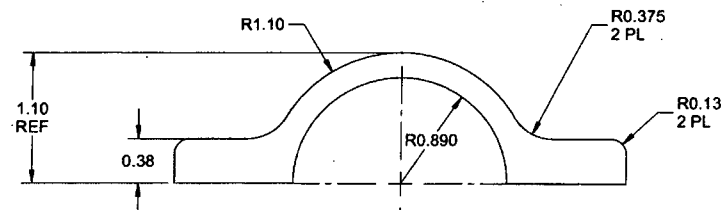
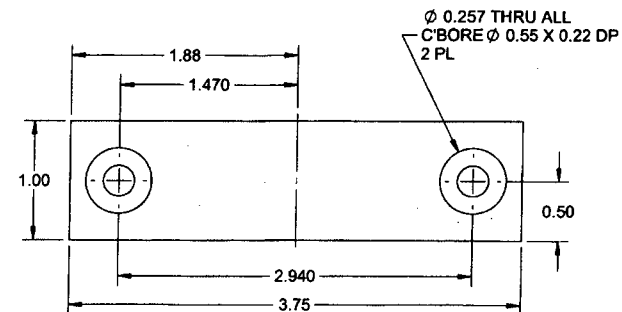


D3440-1 TUBE GUIDE
SUPERSEDES PREMIER P/N B67-43001-25/-307

D3440-1/-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS-QQ/A200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N D3440-X PER DART QSI 044 6.1
- 7) WEIGHT: D3440-1=0.35 lb
D3440-3=0.11 lb
- 8) MASK BEFORE PAINTING.
- 9) DRILL HOLE AT ASSEMBLY.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
D. 139211 MLJ
15-12-03



D3440-3 CLAMP
SUPERSEDES PREMIER P/N B67-43001-309

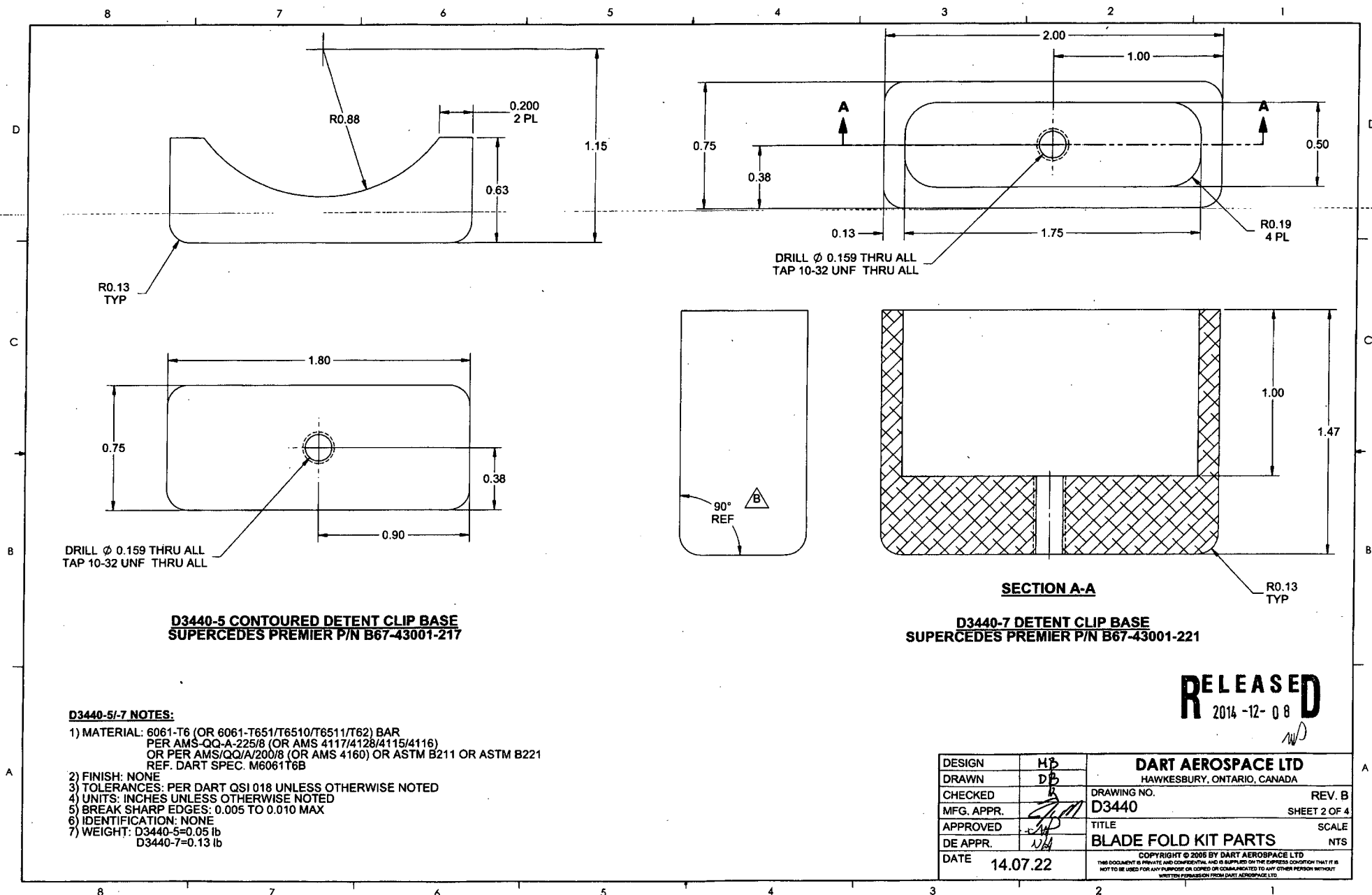
RELEASED
2014-12-08

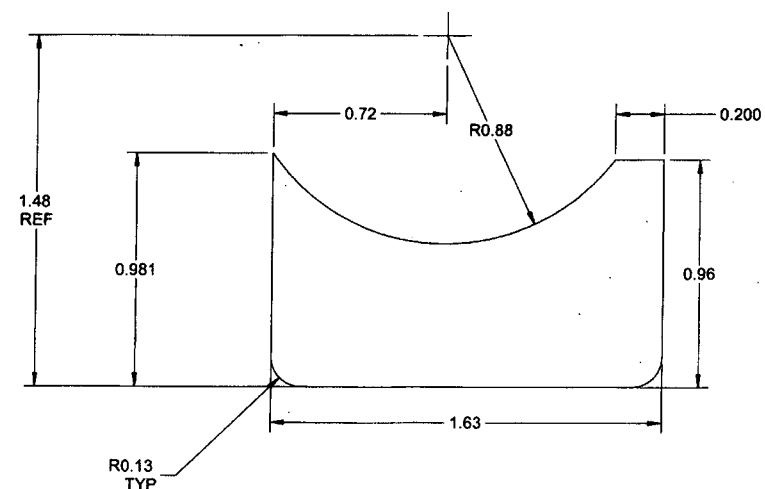
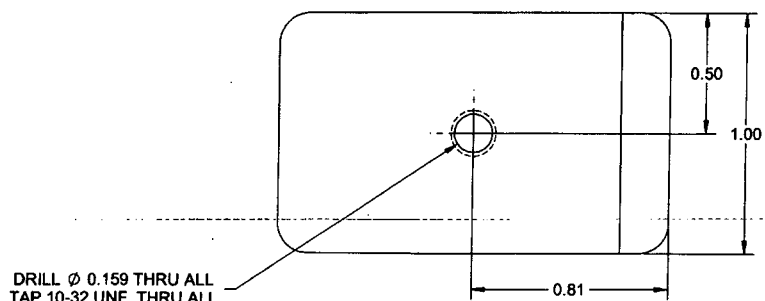
B	RE-FORMAT DWG TO CURRENT STANDARD, 90° WAS 93° (ZN B4-2), 0.132 DEEP WAS 0.085 DEEP (ZN C4-4) REASON FACILITATE MANUFACTURING	DB	14.07.22
A	NEW ISSUE	MB	05.06.02
REV.	DESCRIPTION	BY	DATE
DESIGN	MB		
DRAWN	DB		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	14.07.22		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3440** REV. B
TITLE **BLADE FOLD KIT PARTS** SHEET 1 OF 4
SCALE NTS

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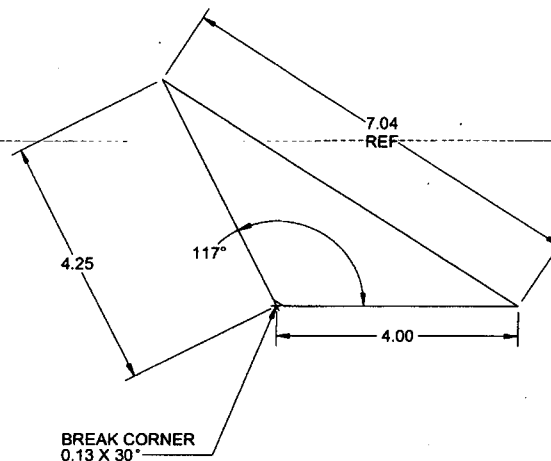




D3440-9 TUBE DETENT CLIP BASE
SUPERCEDES PREMIER P/N B67-43001-241

D3440-9 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ-A/200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.11 lb



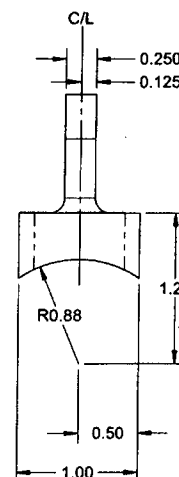
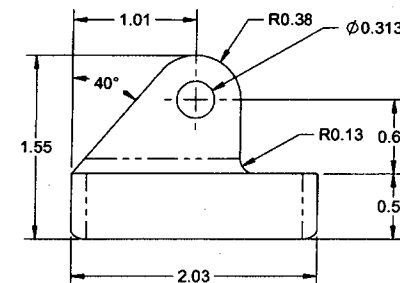
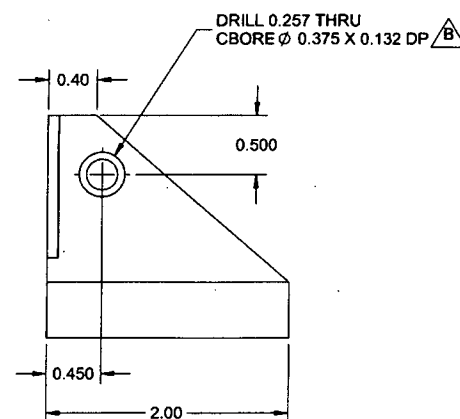
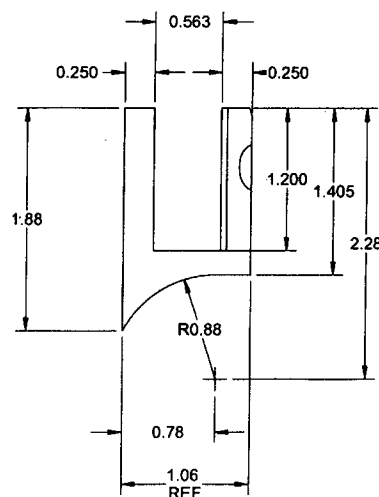
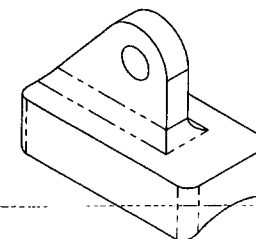
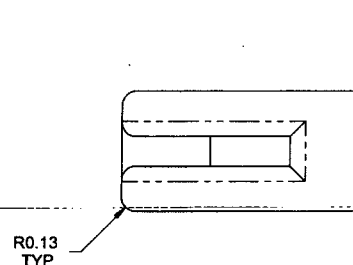
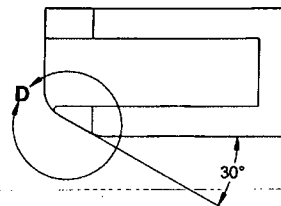
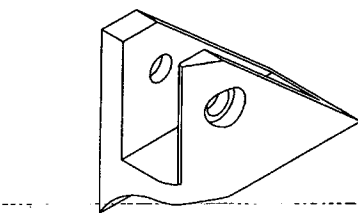
D3440-11 GUSSET

D3440-11 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF. DART SPEC. M6061T6S.250
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.18 lb

RELEASED
2014-12-08

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.		D3440	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BLADE FOLD KIT PARTS	NTS
DATE	14.07.22	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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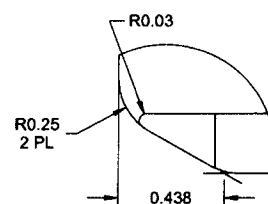
D3440-13 BRACKET
SUPERCEDES PREMIER P/N B67-43001-273

D3440-15 CONTOURED MALE EYE
SUPERCEDES PREMIER P/N B67-43001-215

D3440-13-15 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ-A/200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3440-13=0.11 lb
D3440-15=0.11 lb

DETAIL D
SCALE 2X



RELEASED
2014-12-08

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	13	DRAWING NO.	REV. B
MFG. APPR.		D3440	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.	14/8	BLADE FOLD KIT PARTS	NTS
DATE	14.07.22	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	